

# Work Order ID 84775

Wednesday, May 23, 2012 8:36:00 AM

**\*84775\***

Ship May 28<sup>th</sup> Page 1

Item ID: D212-725-1-123

Revision ID:

Item Name: Bracket

Start Date: 5/23/2012 Start Qty: 1.00

Required Date: 5/28/2012 Req'd Qty: 1.00

Reference:

Flat pattern  
\*1\* only  
\*1\*

**\*N9000040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: *MC*

Date: 12-05-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4235    | A            |

|     |  |      |
|-----|--|------|
| 110 |  | 0.00 |
|-----|--|------|

**\*110\***

Waterjet

FLOW CNC Waterjet

2024 .063

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

1 0 JM  
12-5-23

|     |                                   |      |
|-----|-----------------------------------|------|
| 120 | QC8- Inspect parts - second check | 0.00 |
|-----|-----------------------------------|------|

**\*120\***

QC

Quality Control

Memo

0.00

1 0 JM  
12-5-23

|     |   |      |
|-----|---|------|
| 130 | QC2- Inspect parts off machine FAI/FAIB | 0.00 |
|-----|---|------|

**\*130\***

QC

Quality Control

Memo

0.00

1 JM  
12-05-23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 84775

**\*84775\***

Page 2

Wednesday, May 23, 2012 8:36:00 AM

Item ID: D212-725-1-123

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 5/23/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/28/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Form as per dwg

0.00

**\*140\***

Brake NC

Memo

AND FLANGE HOLES AFTER BEND AS PER DWG

0.00

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

ME  
12-05-28

ME  
12-05-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 84775**

Wednesday, May 23, 2012 8:36:00 AM

**\*84775\***

Page 3

Item ID: D212-725-1-123

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 5/23/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/28/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC3 Inspect Chemical Conversion Coat

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

**\*180\***

SprayPaint

Memo

0.00

Spray Painting

PRIME and PAINT as per dwg

PRIMER BATCH: \_\_\_\_\_

PAINT BATCH: \_\_\_\_\_

190

QC14- Inspect Spray Paint

0.00

**\*190\***

QC

Memo

0.00

Quality Control

N  
A  
MF 12.05.29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 84775

**\*84775\***

Page 4

Wednesday, May 23, 2012 8:36:00 AM

Item ID: D212-725-1-123

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 5/23/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/28/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

*send to Mark Eagle as is*

*12/5/29*

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

*MF*

*MLJ 12/05/29*

*MF 12-05-29*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 23, 2012 8:35:59 AM

Page 1

Work Order ID: 84775

Parent Item: D212-725-1-123

Parent Item Name: Bracket

Start Date: 5/23/2012

Required Date: 5/28/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063                    |                        | Purchased     | No          |                     |                  | 110             | sf                 | 363.7700       | 2.597       | 2.7336842    |               |                |        |
| 2024-T3 .063 sheet              |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

Location

Loc Qty

Loc Code

MAT022

363.77

119916

140.77

121197

223

121197

Jm

12-5-23

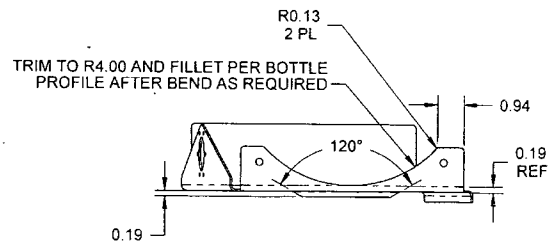
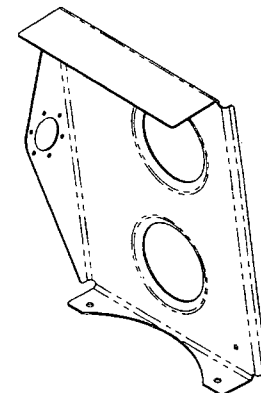
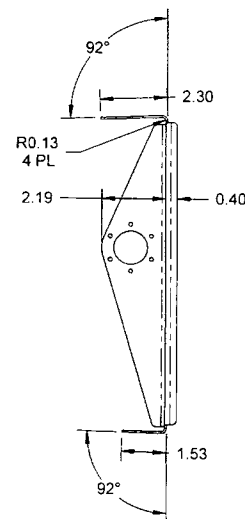
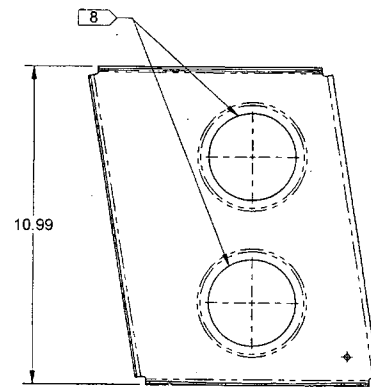
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D212-725-1-123 BRACKET**  
(MAKE FROM D212-725-1-123F FLAT PATTERN)

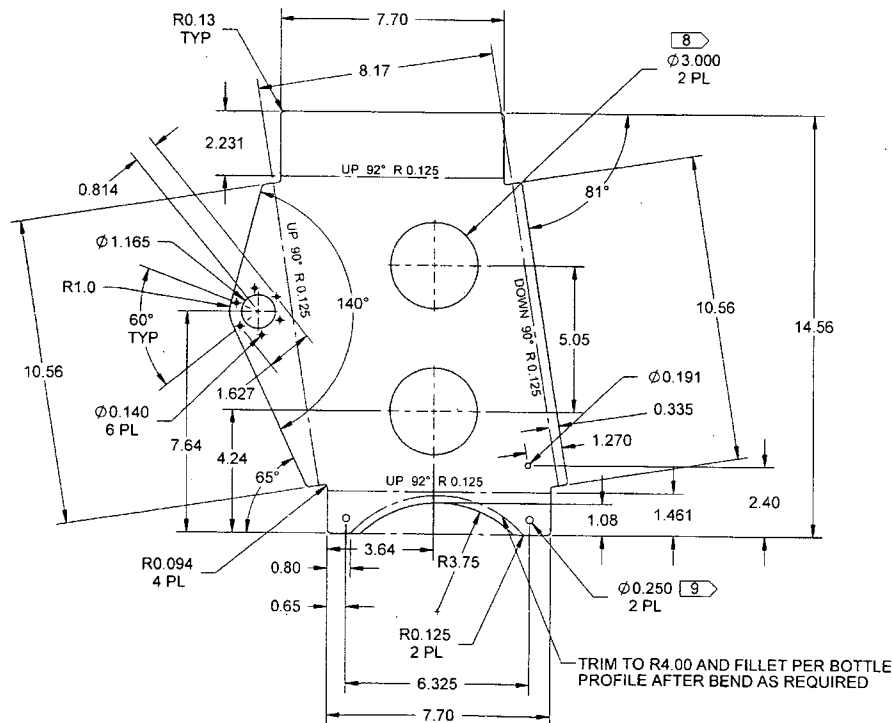
**NOTES:**

- 1) MATERIAL: MAKE FROM D212-725-1-123F FLAT PATTERN
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) USE 3.0 FLANGE TOOL AFTER BEND, 2 PLACES

# 84775

**RELEASED**  
2011-08-25

|             |             |  |              |
|-------------|-------------|--|--------------|
| A NEW ISSUE |             | RF   | 11.02.24     |
| REV.        | DESCRIPTION |  | BY DATE      |
| DESIGN      | RF          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN       | RF          |  |              |
| CHECKED     |             | DRAWING NO.  | REV. A       |
| MFG. APPR.  |             | D4235  | SHEET 1 OF 2 |
| APPROVED    |             | TITLE  | SCALE        |
| DE APPR.    |             | BRACKET  | NTS          |
| DATE        | 11.02.24    | <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |



# NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
REF DART SPEC. M2024T3S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) USE 3.0 FLANGE TOOL AFTER BEND, 2 PLACES
- 9) TRANSFER FROM AIRCRAFT FIRE EXTINGUISH BOTTLE

## **D212-725-1-123F FLAT PATTERN**

RELEASED  
2011-08-25  
JWP

|            |                    |  |              |
|------------|--------------------|--|--------------|
| DESIGN     | RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | RF                 |  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.  | REV. A       |
| MFG. APPR. | <i>[Signature]</i> | D4235  | SHEET 2 OF 2 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | BRACKET  | NTS          |
| DATE       | 11.02.24           | COPYRIGHT © 2011 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

|   |  |                                     |
|---|--|-------------------------------------|
| <b>DART AEROSPACE LTD</b>                                   |  | <b>Work Order:</b> 84775            |
| <b>Description:</b> Bracket                                 |  | <b>Part Number:</b> D212-725-1-123F |
| <b>Inspection Dwg:</b> D212-725-1 Pg 40 of 84 <b>Rev:</b> F |  | <b>Page 1 of 1</b>                  |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.140            | +0.005/-0.001 | 0.142            | ✓      |        | ✓                    | HB-02    |
| Ø0.191            | +0.005/-0.001 | 0.194            | ✓      |        | ✓                    | HB-02    |
| Ø1.165            | +0.012/-0.001 | 1.165            | ✓      |        | ✓                    | HB-02    |
| 7.70              | +/-0.030      | 7.706            | ✓      |        | ✓                    | HB-02    |
| 10.56             | +/-0.030      | 5                |        |        |                      |          |
| 14.56             | +/-0.030      |                  |        |        |                      |          |
| 5.05              | +/-0.030      | 5.059            | ✓      |        | ✓                    | HB-02    |
| 1.270             | +/-0.010      | 1.272            | ✓      |        | ✓                    | HB-02    |
| 2.40              | +/-0.030      | 2.397            | ✓      |        | ✓                    | HB-02    |
| 4.24              | +/-0.030      | 4.247            | ✓      |        | ✓                    | HB-02    |
| 0.063             | +/-0.010      | 0.065            | ✓      |        | ✓                    | HB-02    |
| Ø3.000            | +0.012/-0.001 | 3.002            | ✓      |        | ✓                    | HB-02    |
| Grain Direction   | ✓             |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                                |                              |
|------------------------|--------------------------------|------------------------------|
| <b>Measured by:</b> JM | <b>Audited by:</b> [Signature] | <b>Preliminary Approval:</b> |
| <b>Date:</b> 12-5-23   | <b>Date:</b> 12-05-23          | <b>Date:</b>                 |

| Rev | Date     | Change    | Revised by | Approved    |
|-----|----------|-----------|------------|-------------|
| A   | 10.11.15 | New Issue | KJ         | [Signature] |